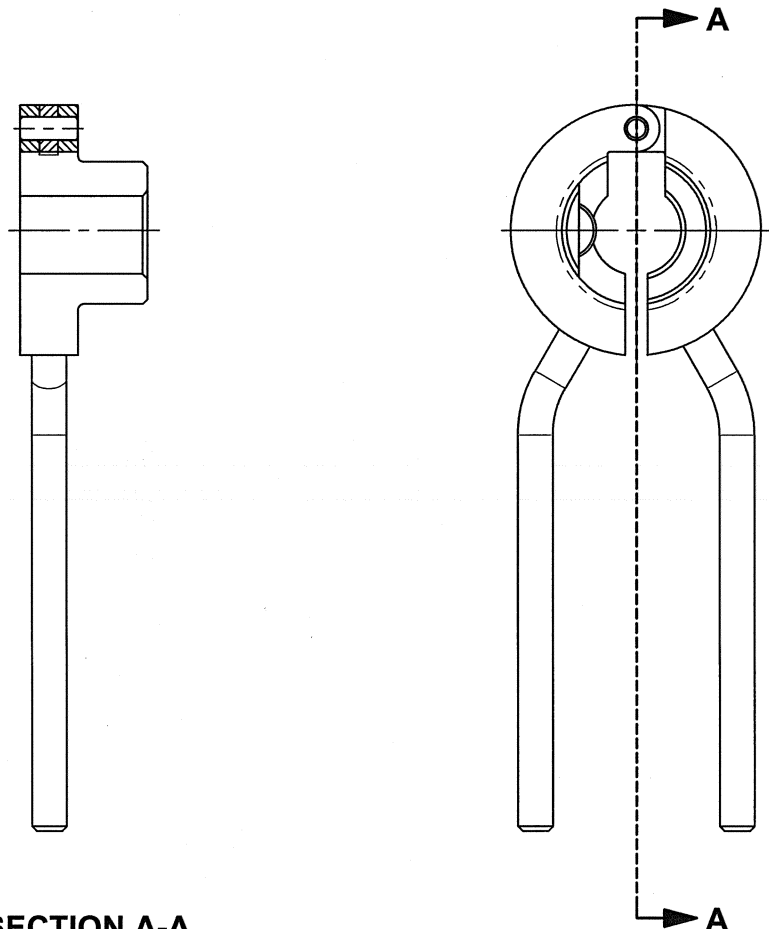
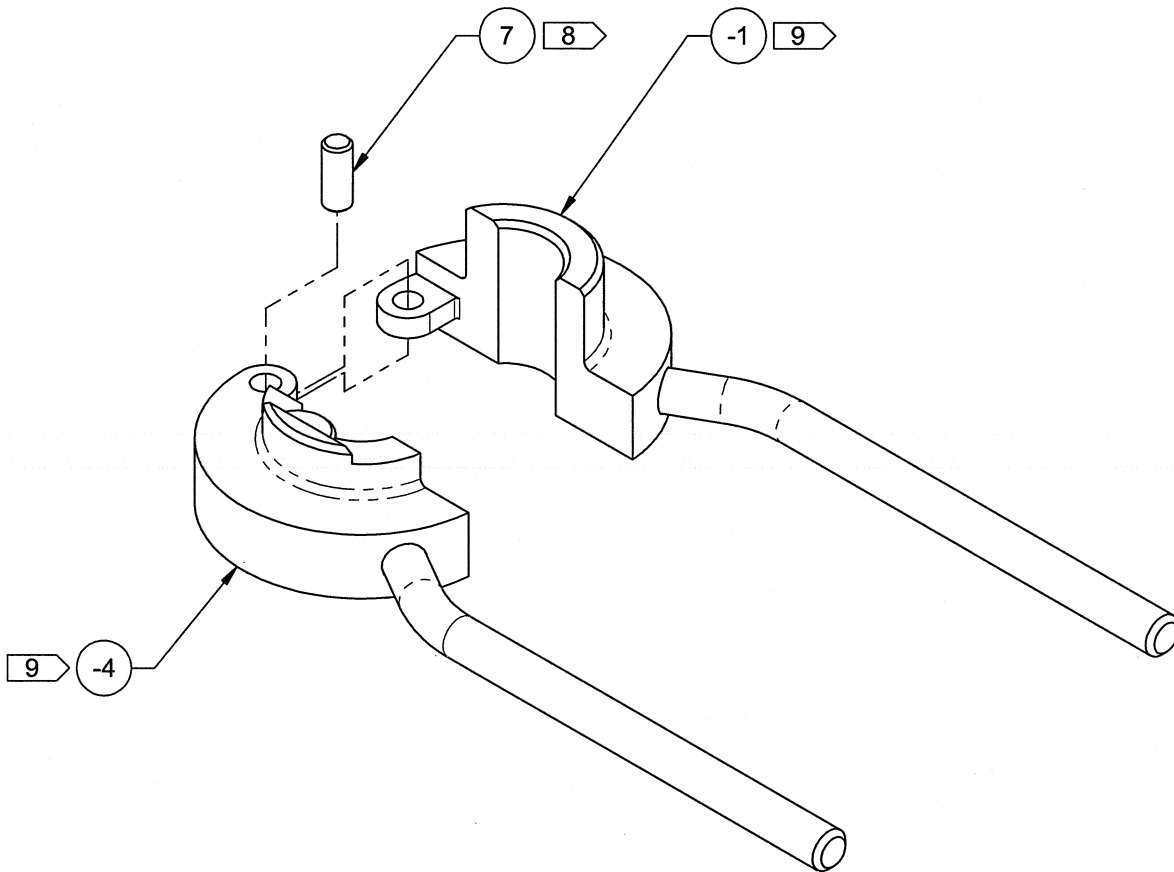


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6798925-1	JAW WELDMENT
-4	1	RBW6798925-4	CRIMPER JAW WELDMENT #1
7	1	McMaster#98381A539 OR EQUIV.	STEEL DOWEL PIN 1/4" DIA. X 5/8" LG.

SEE ATTACHED DEVIATION



SECTION A-A



RB6798925 GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT

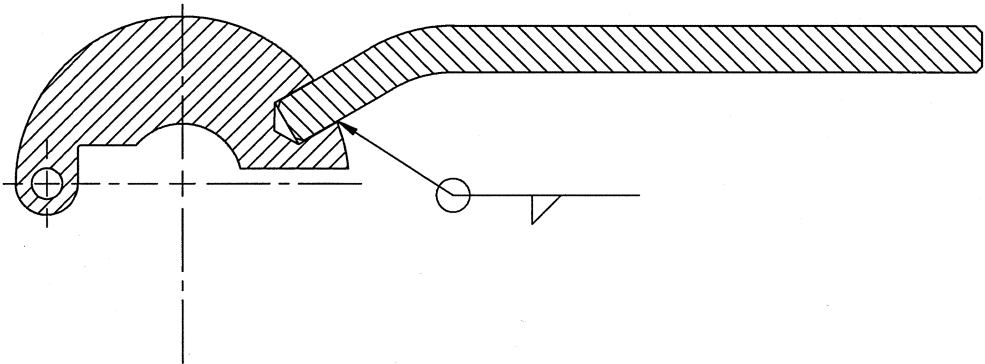
10

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 7 WITH ITEM -1, AND REMOVE EXCESS
 - 9) ITEM -1 AND ITEM -4 MUST ROTATE FREELY
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

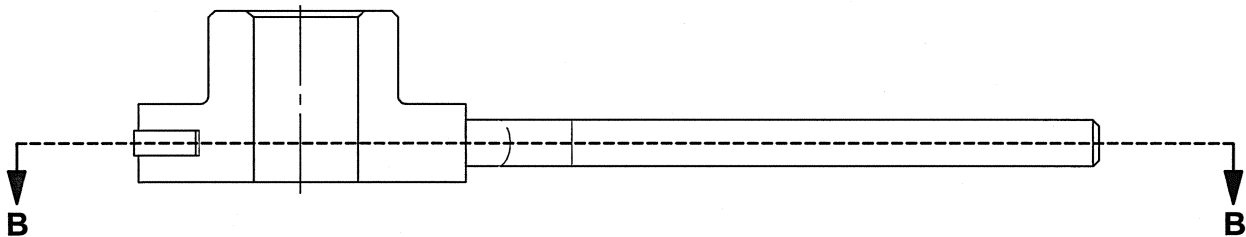
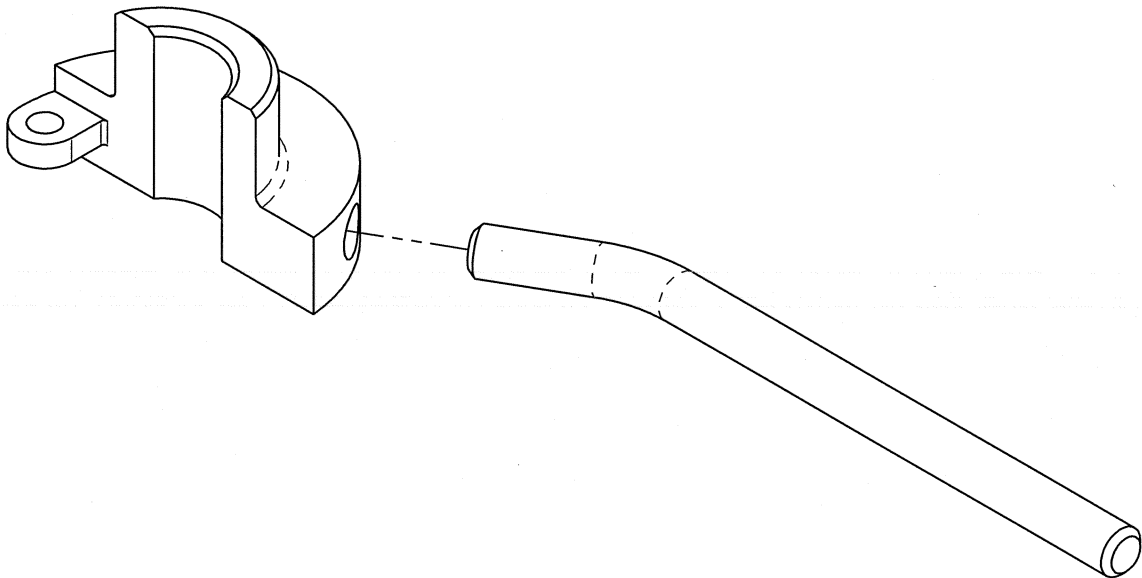
A	NEW ISSUE	19-763	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB6798925	SHEET 1 OF 8
APPROVED	WJP	TITLE	SCALE
		GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT	NTS
DATE	2019-06-07	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB6798925-2	JAW
-3	1	RB6798925-3	HANDLE

SEE ATTACHED DEVIATION






SECTION B-B



RBW6798925-1 JAW WELDMENT

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: 32-36 RC
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 2 OF 8
DRAWN	KPT			
CHECKED	KPT	TOOL PART # RB6798925		SCALE NTS 
MFG. APPR.	JFC	TITLE GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT		
APPROVED		DATE 2019-06-07		
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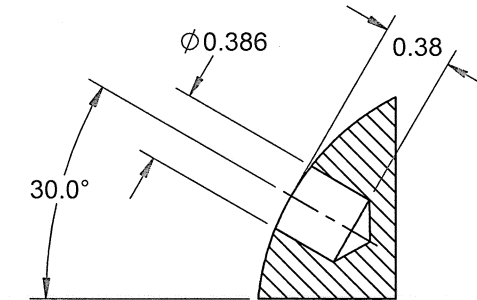
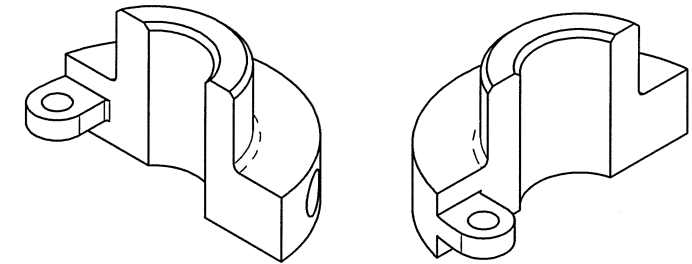
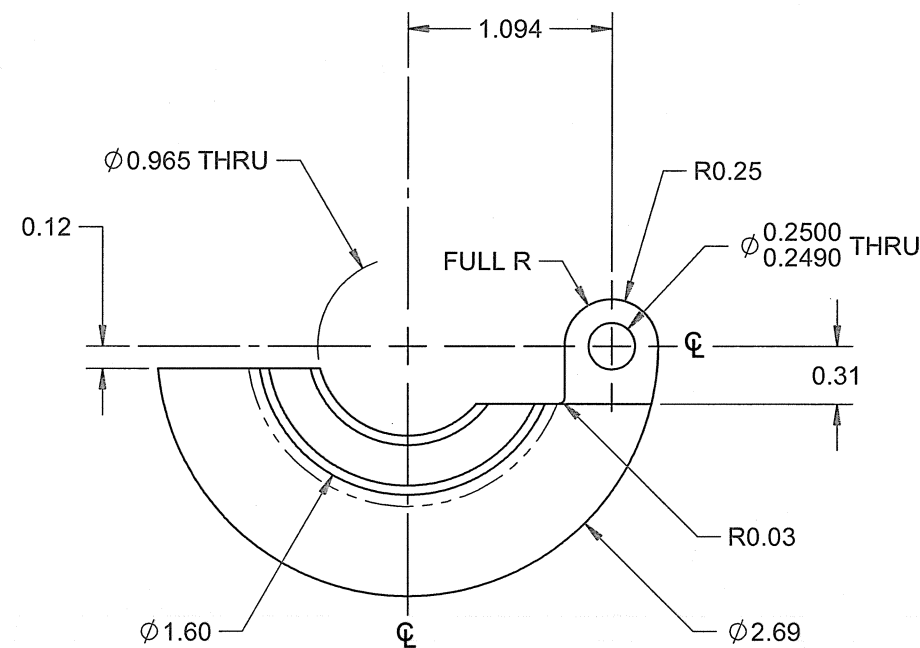
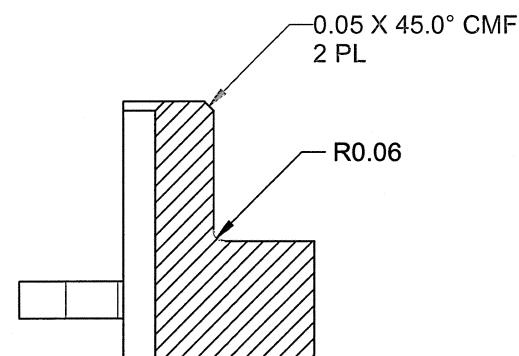
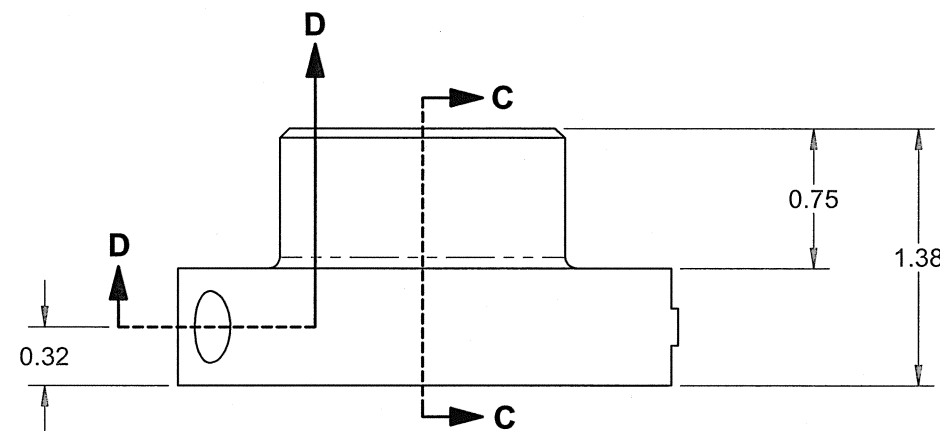
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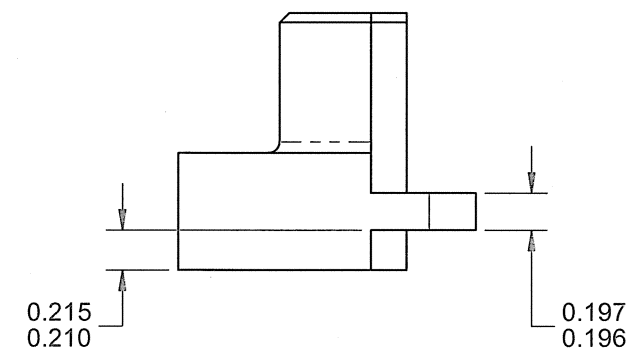
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**SECTION D-D****SECTION C-C****RB6798925-2 JAW**



8

**SEE ATTACHED DEVIATION****NOTES:**

- 1) MATERIAL: 4140
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) DIMENSIONS MUST BE MET AFTER PLATING AS PER ITEM -1 WELDMENT

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB6798925	SHEET 3 OF 8
APPROVED		TITLE	SCALE
		GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT	NTS 
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DATE 2019-06-07

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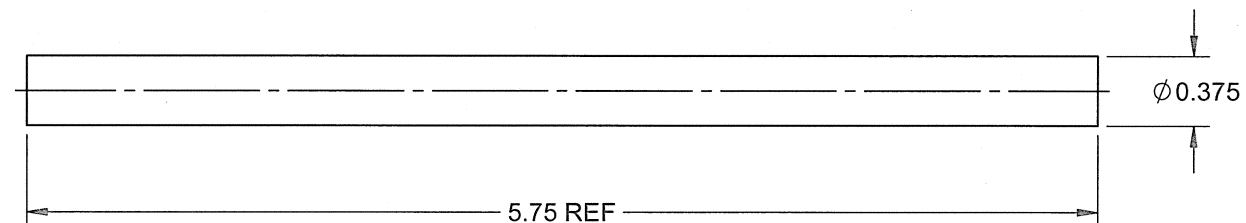
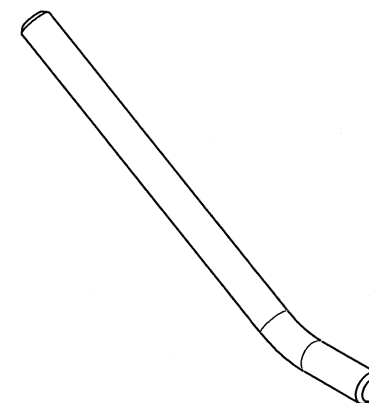
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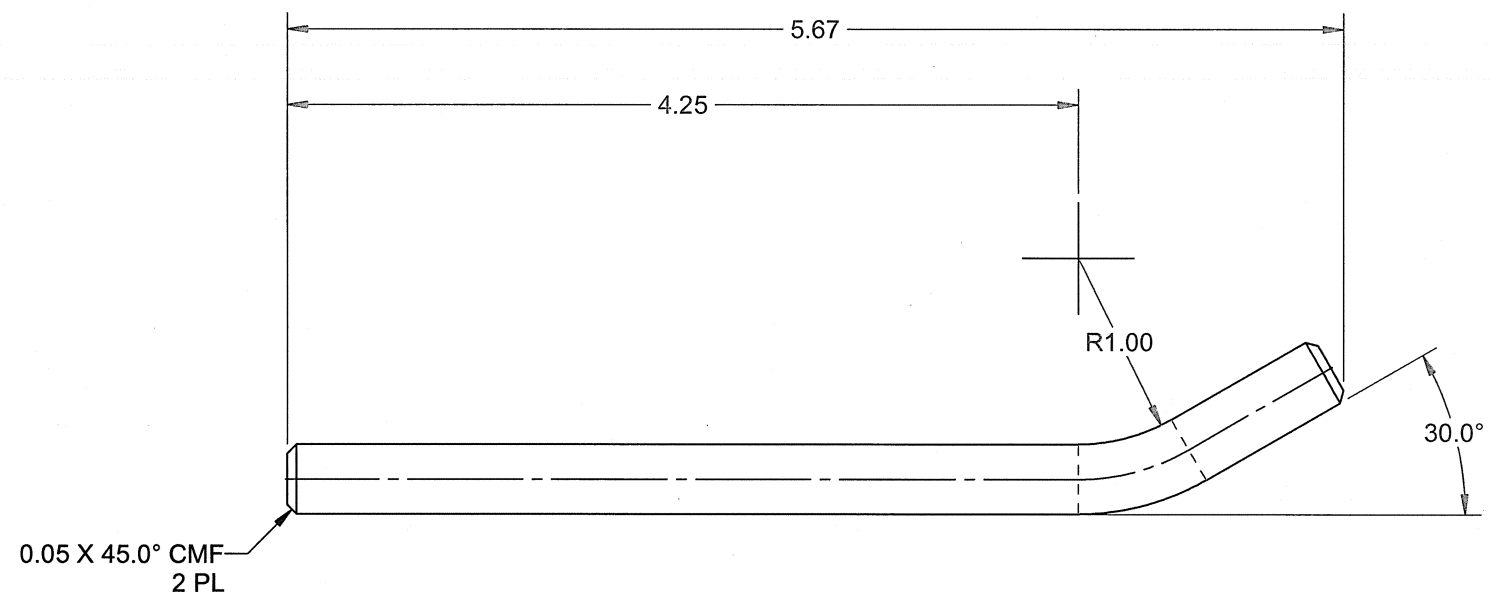
D

D

**FLAT PATTERN**

C

C

**RB6798925-3 HANDLE**

8

B

B

NOTES:

- 1) MATERIAL: 4140
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING AS PER ITEMS -1 AND -4 WELDMENTS

SEE ATTACHED DEVIATION

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB6798925	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DATE	2019-06-07	GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT	NTS
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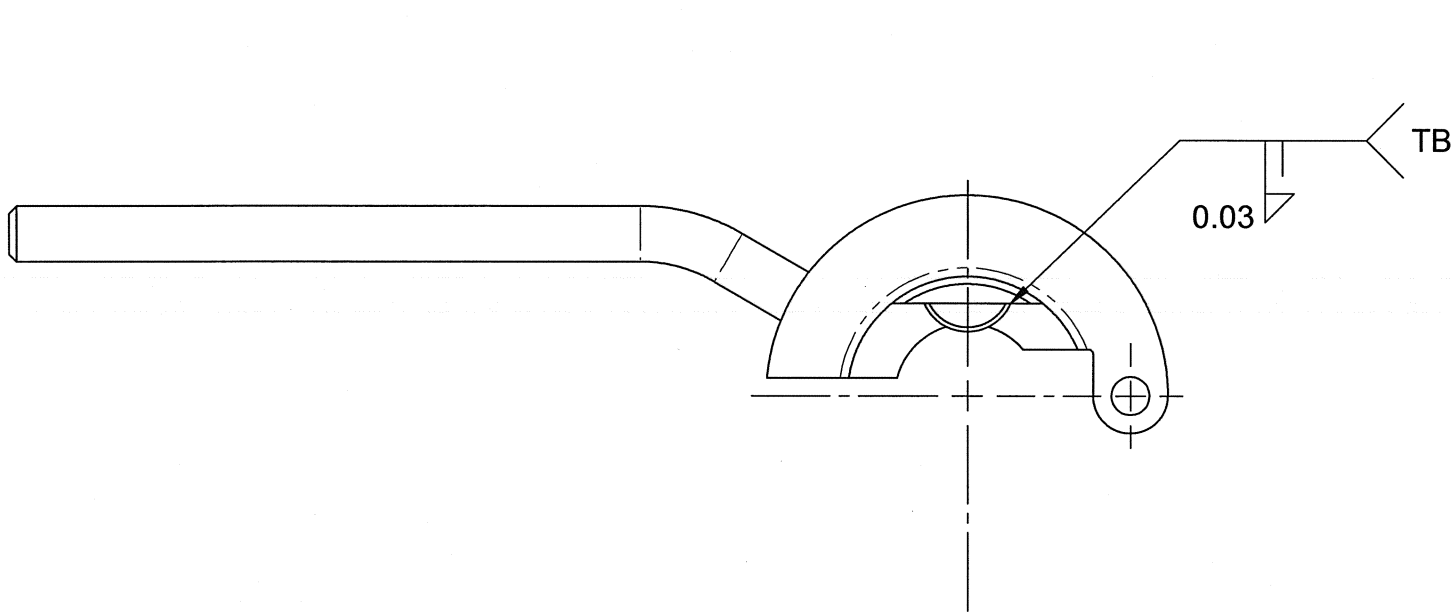
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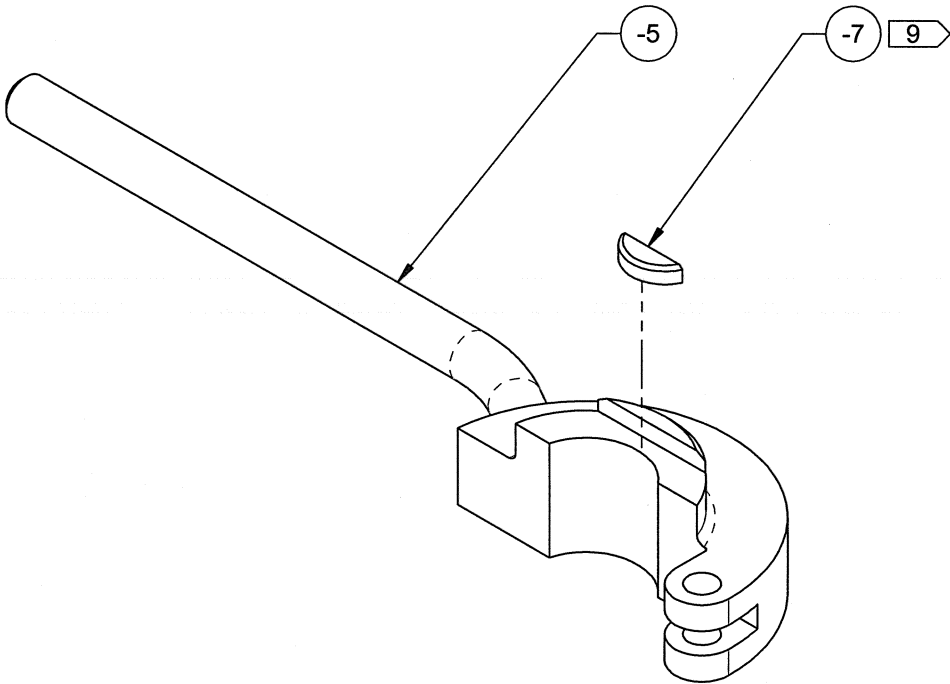
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB6798925-5	CRIMPER JAW WELDMENT #2
-7	1	RB6798925-7	ADAPTER MOUNT





RBW6798925-4 CRIMPER JAW WELDMENT #1

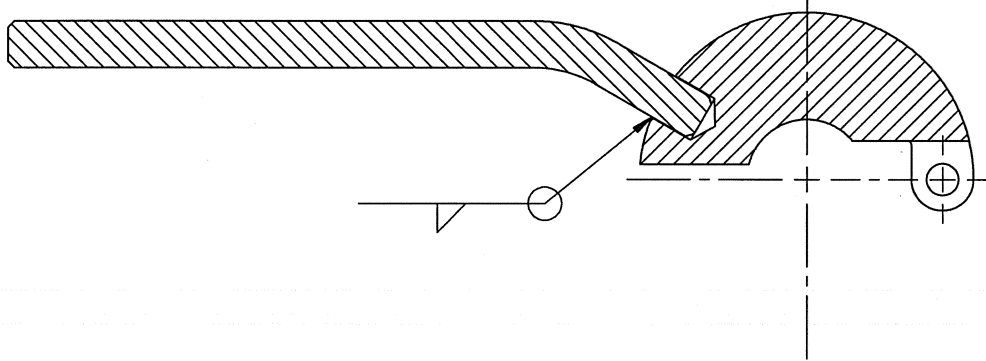


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS
 - 9) BRAZE ITEM -7 TO ITEM -5

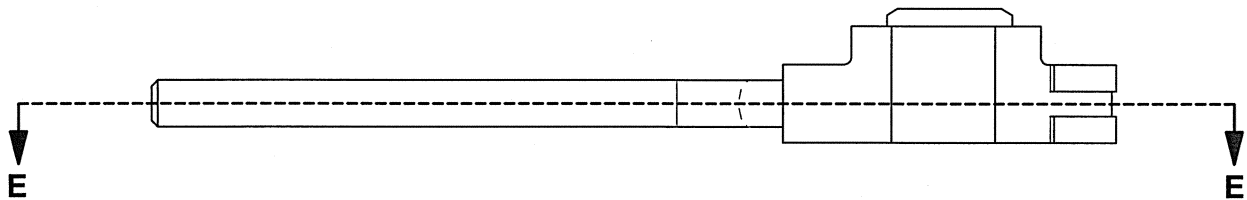
SEE ATTACHED DEVIATION

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB6798925	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DATE 2019-06-07		GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT	NTS 
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ITEM #	QTY	PART #	PART TITLE
-3	1	RB6798925-3	HANDLE
-6	1	RB6798925-6	CRIMPER JAW



SECTION E-E



RB6798925-5 CRIMPER JAW WELDMENT #2

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: 32-36 RC
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

SEE ATTACHED DEVIATION

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB6798925	SHEET 6 OF 8
APPROVED	Wp	TITLE	SCALE
DATE	2019-06-07	GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT	NTS
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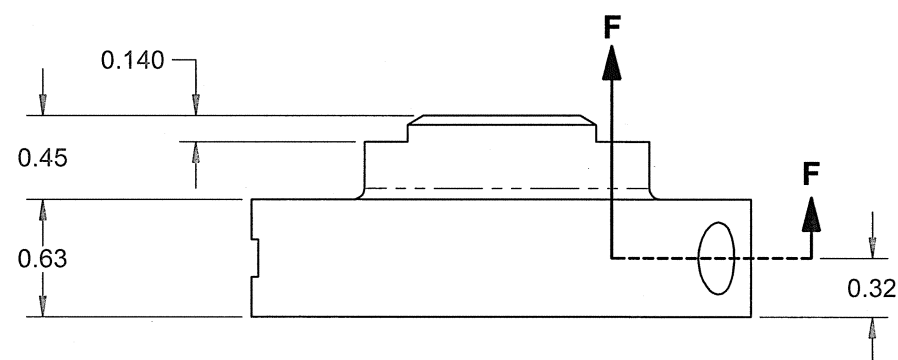
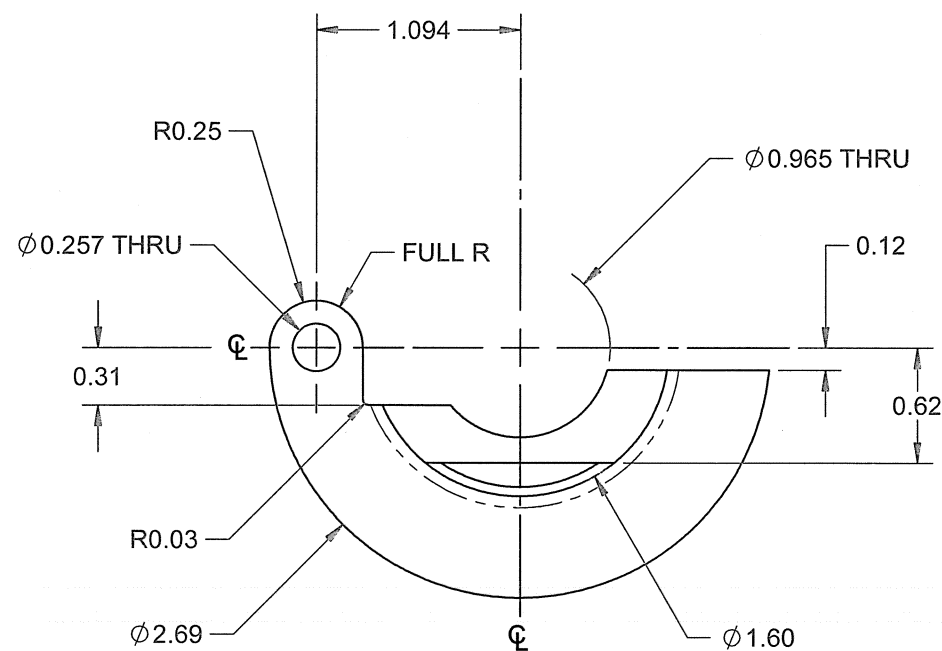
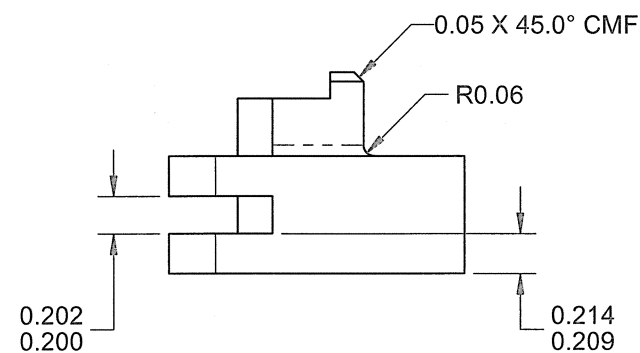
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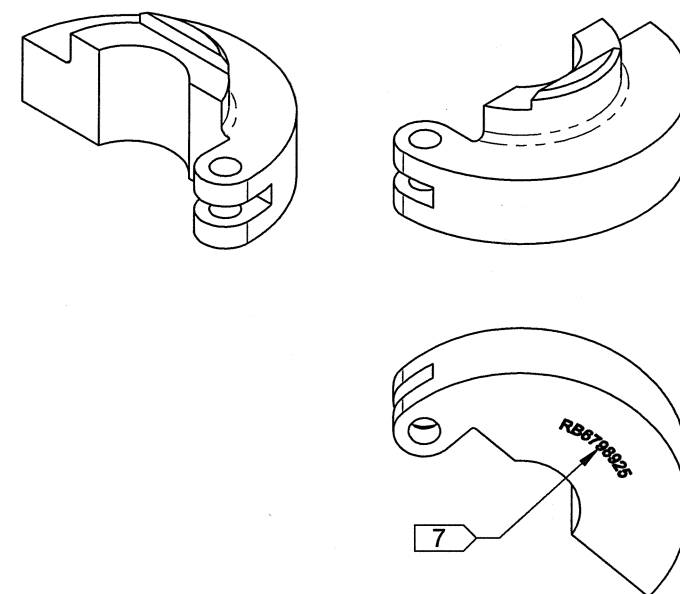
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**RB6798925-6 CRIMPER JAW**

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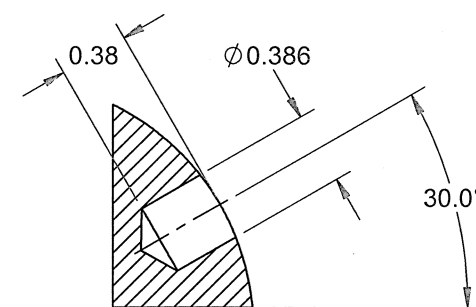


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

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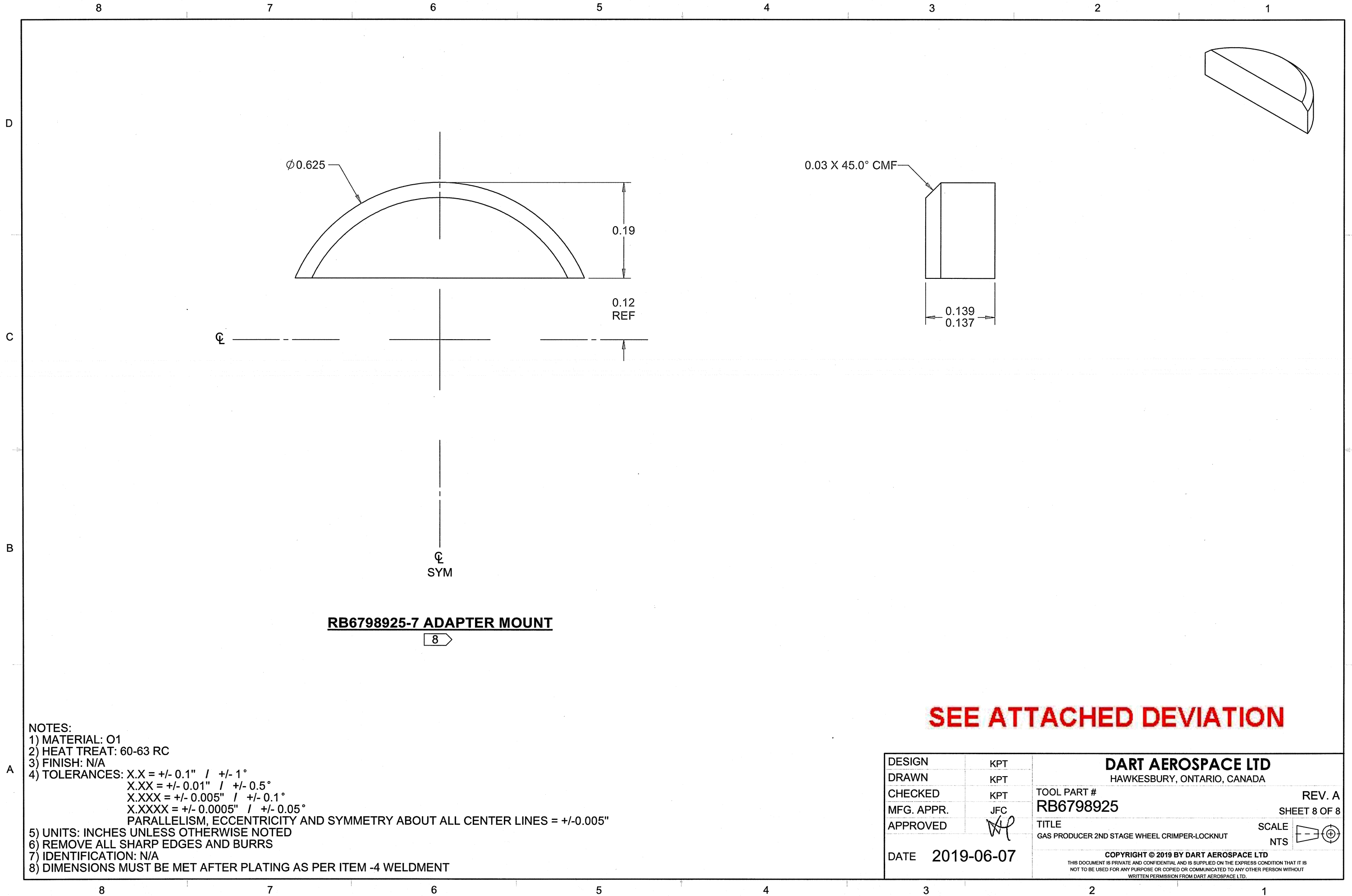
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**SECTION F-F****NOTES:**

- 1) MATERIAL: 4140
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB6798925", AS SHOWN
- 8) DIMENSIONS MUST BE MET AFTER PLATING AS PER ITEM -4 WELDMENT

SEE ATTACHED DEVIATION

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RB6798925	SHEET 7 OF 8
APPROVED		TITLE	SCALE
		GAS PRODUCER 2ND STAGE WHEEL CRIMPER-LOCKNUT	NTS 
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBG798925</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>		
Date : <u>2019-08-06</u>	Sequence #:	QTY Affected :	MRB (QSI042) 	
Description Work Order Deviation		Disposition		Completed By
WAS : BRAZING IS : 1/32" FILLER TIG WELDING MUCH CLEANER AND COSMETIC LOOK WITHOUT COMPROMISING STRENGTH		THIS DEVIATION IS ACCEPTABLE TO USE AS IS FIT, FORM AND FUNCTION WILL BE AS ORIGINALLY INTENDED		
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input checked="" type="checkbox"/></div> <div>Process Improvement <input checked="" type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>		
Other/Details:				